

Thursday, 11/23/2006 11:53:10 AM

Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	: 29661					
Estimate Number	: 10531		Part Number	: D2572		
P.O. Number	: N/A		Drawing Number	: D2572 REV E		
This Issue	: 11/23/2006	S.O. No. : N/A	Project Number	: N/A		
Prsht Rev.	: NC		Drawing Revision	: E		
First Issue	: N/A		Material	: N/A		
Previous Run	: 29511		Due Date	: 12/20/2006		
Written By			Qty:	12	Um:	Each
Checked & Approved By						
Comment	: Est: 102.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101005	7075-T7351 8.25X5.0X2.5	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: 1328351	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. B29661 Double check by: J.G 06/11/09	
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2572 PAR #: N/A Fault Category: Prod/Machines Parts NCR: Yes ○ No ○ DQA: D Date: 06/12/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>29661</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>06/12/04</u>	<u>3.0</u>	<u>Slot is .070 off-center, setup on milling machine moved.</u>	<u>AB</u> <u>06/12/04</u>	<u>Scrap &amp; destroy, replace. Inspect XLO mill for slack. XLO operatable.</u>	<u>SD</u> <u>06/12/04</u>	<u>J</u> <u>06/12/04</u>	<u>AB</u> <u>06/12/04</u>	<u>J</u> <u>06/12/04</u>

NOTE: Date & initial all entries

Date: Thursday, 11/23/2006 11:53:10 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 29661

Part Number: D2572

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

E/S 06.12.02

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 06/12/15

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

A.M/5R

(12)

7.0 POWDER COATING

POWDER COATING



M102391



(12)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m.k/am 06/12/21

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



R.C/12/21



(12)

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5479 EB

6/12/21

R.C/12/21 (12)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

(12) 06/12/22

Job Completion



u do.12/22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29661
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.506	3.500	3.500		
D	1.745	1.755		1.749	1.750	1.750	1.750		
E	7.990	8.010		7.999	7.999	7.999	7.999		
F	0.490	0.510		0.502	0.503	0.503	0.500		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DI8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.498	0.498	0.497	0.498		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		0.565	0.565	0.566	0.564		
L	1.174	1.184		1.178	1.178	1.179	1.178		
M	1.490	1.500		1.494	1.495	1.495	1.495		
N	2.495	2.505		2.499	2.500	2.500	2.500		
O	3.869	3.879		3.873	3.872	3.871	3.872		
P	0.115	0.135		0.126	0.125	0.125	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.249	0.249	0.249	0.251		
S	0.115	0.135		0.133	0.132	0.132	0.132		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.243	0.242	0.240	0.241		
W	0.115	0.135		0.130	0.130	0.130	0.130		
X	0.307	0.312		0.309	0.309	0.310	0.308		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.367	0.366	0.367	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.630	0.630	0.630	0.630		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.249	0.247	0.249		
AE	1.375	1.395		1.382	1.382	1.382	1.383		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.252	0.250	0.249	0.251		
AI	2.000	2.020							
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by: *mL*  
Date: 06/12/01

Audited by: *J.L.*  
Date: 06/12/01

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>2f</i>	<i>JLM</i>

DART AEROSPACE LTD				Work Order:	29661
Description: Saddle, Fwd Inboard				Part Number:	D2572
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	.440	.439	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.756	1.750	1.750	1.749		
E	7.990	8.010		7.999	7.999	8.000	7.998		
F	0.490	0.510		0.500	.500	.496	.496		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.377	.376	.376	.376		
I	0.490	0.510		0.498	.495	.500	.500		
J	1.174	1.184		1.178	1.175	1.175	1.175		
K	0.558	0.578		0.565	.567	.567	.567		
L	1.174	1.184		1.178	1.175	1.175	1.175		
M	1.490	1.500		1.495	1.493	1.493	1.493		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.871	3.871	3.874	3.874		
P	0.115	0.135		0.126	.126	.126	.126		
Q	0.115	0.135		0.135	.135	.135	.135		
R	0.240	0.260		0.251	.250	.250	.251		
S	0.115	0.135		0.133	.133	.129	.133		
T	0.178	0.198		0.188	.188	.188	.188		
U	2.940	2.980		2.960	2.961	2.960	2.960		
V	0.230	0.250		0.242	.243	.240	.243		
W	0.115	0.135		0.130	.128	.129	.128		
X	0.307	0.312		0.309	.312	.312	.313		
Y	0.760	0.765		0.760	.761	.761	.761		
Z	0.352	0.372		0.365	.365	.364	.365		
AA	0.470	0.530		0.500	.500	.500	.500		
AB	0.615	0.635		0.630	.636	.629	.628		
AC	0.053	0.073		0.063	.063	.063	.063		
AD	0.240	0.260		0.249	.249	.248	.248		
AE	1.375	1.395		1.385	1.386	1.386	1.385		
AF	0.115	0.135		0.135	.134	.134	.134		
AG	0.240	0.280		0.260	.260	.255	.253		
AH	0.240	0.260		0.250	.250	.248	.248		
AI	2.000	2.020							
AJ	0.023	0.043		0.030	.030	.030	.030		

Accept/Reject

Measured by:	ML/SD	Audited by:	J.L
Date:	06.02.02	Date:	06/12/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	ML

DART AEROSPACE LTD	Work Order:	29661
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

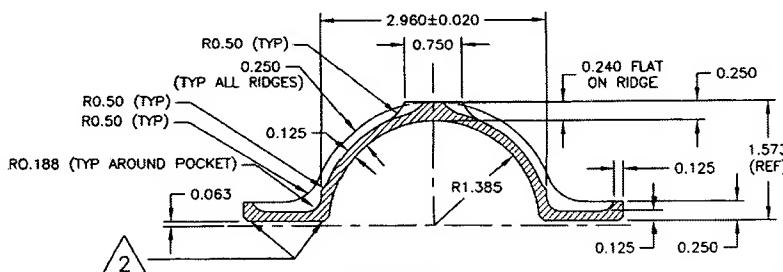
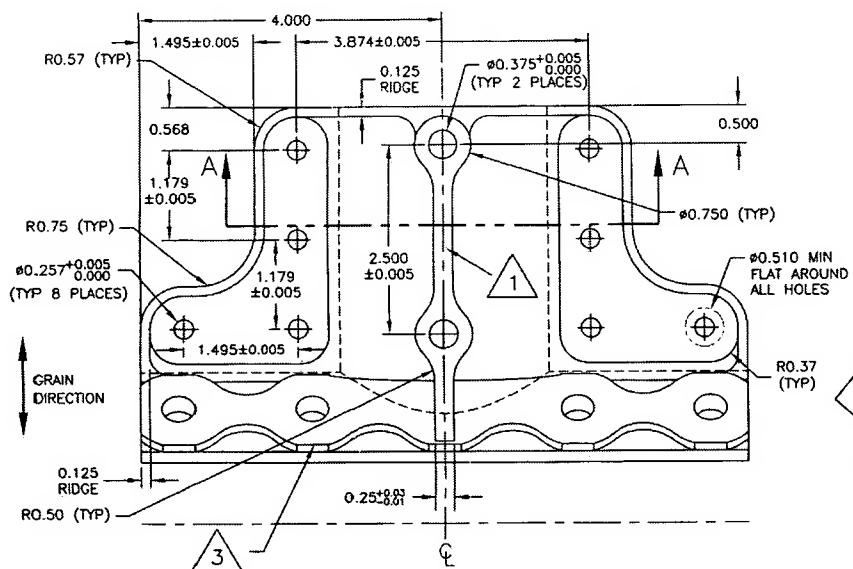
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	.439	.439	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.503	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	7.999	7.999		
F	0.490	0.510		.500	.497	.496	.498		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.376	.376	.376	.376		
I	0.490	0.510		.501	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.566	.567	.568	.566		
L	1.174	1.184		1.175	1.179	1.179	1.179		
M	1.490	1.500		1.493	1.493	1.495	1.495		
N	2.495	2.505		2.500	2.501	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.126	.126	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.248	.250	.248		
S	0.115	0.135		.125	.128	.128	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.241	.241	.241	.241		
W	0.115	0.135		.125	.125	.125	.126		
X	0.307	0.312		.312	.312	.311	.311		
Y	0.760	0.765		.761	.761	.761	.761		
Z	0.352	0.372		.363	.364	.364	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.624	.626	.623	.624		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.251	.250		
AE	1.375	1.395		1.386	1.387	1.386	1.385		
AF	0.115	0.135		.135	.135	.134	.135		
AG	0.240	0.280		.25	.25	.25	.25		
AH	0.240	0.260		.251	.251	.250	.251		
AI	2.000	2.020							
AJ	0.023	0.043		0.036	0.030	0.030	0.030		
Accept/Reject									

Measured by:		Audited by:	
Date:	06.12.02	Date:	06/12/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

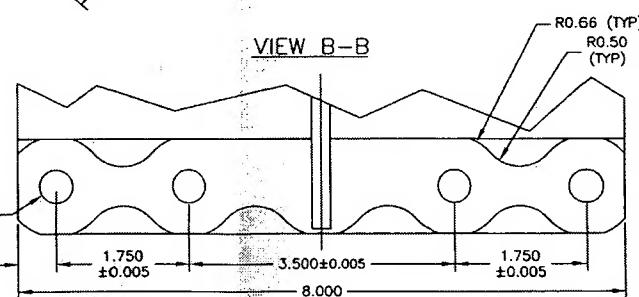
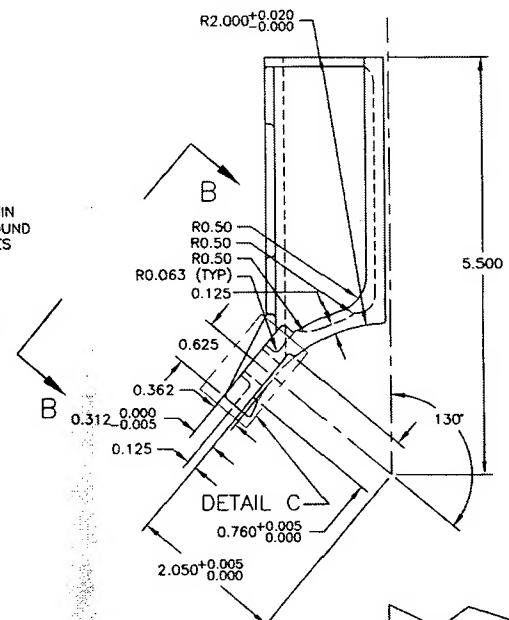
RELEASED

05.12.06



SECTION A-A

DETAIL C  
SCALE 2:1



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DS DRAWN BY PH DART AEROSPACE LTD.  
DRAWING NO. D2572 REV. E  
CHECKED APPROVED SHEET 1 OF 1  
DATE TITLE SCALE  
05.07.13 INNER FWD SADDLE 2:3

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29661

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